

Date: Monday, 25/09/2006 2:52:40 PM
 User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D3121044
Job Number	: 28718		
Estimate Number	: 10804		
P.O. Number	: N/A	Part Number	: Z_CUSTOM
This Issue	: 25/09/2006 S.O. No. : N/A	Drawing Number	: DISASSEMBLE
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : OVERHEAD	Drawing Revision	: N/A
Previous Run	: 00015	Material	: N/A
Written By	: <u>Linda Lacelle</u>	Due Date	: 02/10/2006 Qty: 2 Um: Each
Checked & Approved By	:		
Comment	:		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	PACKAGING 1	PACKAGING RESOURCE #1  <u>B24678</u>  <u>606-0-031</u>	
Comment: PACKAGING RESOURCE #1 <u>1X D3121-044</u> <u>21379</u> <u>U 06-09-25</u> REMOVE FROM STK <u>2 X D3121-044 B</u>			
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 	
Comment: SMALL & MEDIUM FAB RESOURCE 1 REMOVE D3121-21 BOLT FROM D3121-044 <u>D3121-044 B</u> <u>2 X B21378/79</u>  ADJ ACCPAC <u>1x B24678</u> 			
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 	
Comment: SMALL & MEDIUM FAB RESOURCE 1 RE-ASSEMBLE D3121-21 BOLT WHEN AVAILABLE <u>D3121-21 B</u> <u>R9698</u>  <u>mf 07-01-04</u> (3)			
4.0	D312121	Bolt 	
Comment: Qty.: 2.0000 Each(s)/Unit Total: <u>4.0000</u> Each(s) Bolt <u>B 29698</u> 			
5.0	QC5	INSPECT WORK TO CURRENT STEP 	
Comment: INSPECT WORK TO CURRENT STEP <u>07-01-04</u> (3)			

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Drawing Name: D3121044

Job Number: 28718

Part Number: Z_CUSTOM

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	PACKAGING 1	PACKAGING RESOURCE #1
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STK#9



Comment: PACKAGING RESOURCE #1

RETURN TO STK USING NEW B/N *

P 7/1/05 (3)

7.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

(3) 07/01/08

Job Completion



U 07/01/08

DART AEROSPACE LTD	Work Order:	21378/19
Description: Bracket Assembly	Part Number:	D3121-043
04.06.23 C2 C 04.02.19 C4.06.23 CP		D3121-044
Dwg: D3121 Rev. B page 1, 3, 5	Qty:	4 Kits
D3121-043 replaces Premier P/N B30-23000-37		
D3121-044 replaces Premier P/N B30-23000-38		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	KJ	04.08.23	4
2	MV	Cut (1) blank per D3121-13 & (1) blank per D3121-14 Cut blanks (1.00" x 2.00") x 3.250" Long Bar Material: 17-4 SS per AMS 5604/5643 (M17-4-B1.000x02.000)			
		Batch: M1U773	JK	04/09/23	4
3	MV	Machine D3121-13 as per Folio FA329 and Dwg D3121	E	04.11.16	4
4	QC2	Inspect parts as they come off the CNC machine	E	04.11.16	4
5	MV	Machine D3121-14 as per Folio FA329 and Dwg D3121	E	04.11.16	4
6	QC2	Inspect parts as they come off the CNC machine	E	04.11.16	4
7	MV	Deburr Break all sharp edges 0.005 to 0.015	E	04.11.16	4
8	MV	Scribe batch number to D3121-13 & D3121-14 at the back face.	JK	05.01.20	4
9	QC5	Second check D3121-13 and D3121-14	E	05.01.24	4
10	GA	Assemble D3121-043 as per Dwg D3121 Pick: 2 D3121-21	B21881A		
		Qty Part Number Description Batch			
		2 D3121-17 Washer			
		2 D3121-19 Bearing			
		2 MS24694-S50 Screw			
		2 D3121-241	B21855		
11	GA	Assemble D3121-044 as per Dwg D3121 Pick: 2 D3121-21	B21881A		
		Qty Part Number Description Batch			
		2 D3121-17 Washer			
		2 D3121-19 Bearing			
		2 MS24694-S50 Screw			
		2 D3121-741	B21855		
12	QC5	Inspect work to Step 10 & 11			
13	ST	Identify and Stock in Spacedoor cell	D3121-043 Qty 4 D3121-044 Qty 4		
14	AC	Parts to Stock and Prorate Cost to parts per Step 13 Cost / part 129.18 129.22			
15	DC	Close W/O 92.14 129.22 Inspect Level 21			

Rev	Date	Change	Revised By	Approved
A	02.05.21	New issue	NG	
B	03.05.02	Reformat	KJ/RF	CH

REFERENCE ONLY

RELEASED
03.05.06 T2

5/46

DART AEROSPACE LTD	Work Order:	24678
Description: Bracket Assembly	Part Number:	D3121-043 D3121-044✓
Dwg: D3121 Rev. C2 page 1, 3, 5	Qty:	4 Kits
D3121-043 replaces Premier P/N B30-23000-37		
D3121-044 replaces Premier P/N B30-23000-38		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Dwg not required		05.10.26	4
2	MV	Cut (1) blank per D3121-13 & (1) blank per D3121-14 Cut blanks (1.00" x 2.00") x 3.250" Long Bar Material: 17-4 SS per AMS 5604/5643 (M17-4-B1.000x02.000) Batch: <u>14773</u>	JL	05.11.14	8
3	MV	Machine D3121-13 as per Folio FA329 and Dwg D3121	JL	05.11.17	4
4	QC2	Inspect parts as they come off the CNC machine	JL	05.11.17	4
5	MV	Machine D3121-14 as per Folio FA329 and Dwg D3121	JL	05.11.18	4
6	QC2	Inspect parts as they come off the CNC machine	JL	05.11.18	4
7	MV	Deburr Break all sharp edges 0.005 to 0.015	JL	05.11.18	4
8	MV	Scribe batch number to D3121-13 & D3121-14 at the back face.	JL	05.11.18	8
9	QC5	Second check D3121-13 and D3121-14	JL	05.11.18	8
10	GA	Assemble D3121-043 as per Dwg D3121 Pick: <u>Qty</u> <u>Part Number</u> <u>Description</u> <u>Batch</u> 2 D3121-21 Bolt <u>B24678</u> 2 D3121-241 Bearing Assembly <u>B24777</u> Identify as D3121-043	REFERENCE ONLY	05.11.20	4
11	GA	Assemble D3121-044 as per Dwg D3121 Pick: <u>Qty</u> <u>Part Number</u> <u>Description</u> <u>Batch</u> 2 D3121-21 Bolt <u>B244753</u> 2 D3121-241 Bearing Assembly <u>B24777</u> Identify as D3121-044		05.11.20	4+4
12	QC5	Inspect work to Step 10 & 11	BL	05.11.20	4+4
13	ST	Identify and Stock in Spacedoor cell D3121-043 Qty <u>4</u> <u>Loc 403</u> D3121-044 Qty <u>4</u>	BL	05.11.21	4+4
14	AC	Parts to Stock and Prorate Cost to parts per Step 13 Cost / part: _____			
15	DC	Close W/O Inspect Level 21	BL	05.11.23	8

Rev	Date	Change	Revised By	Approved
A	02.05.21	New issue	NG	
B	03.05.02	Reformat	KJ/RF	
C	05.01.27	Revised Steps 10-11	KJ/JLM	

RELEASED
05.01.27